

Date: Monday, 6/5/2006 11:01:24 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CHAFING SHIELD
 Job Number : 27414
 Estimate Number : 10840
 P.O. Number : NIA Part Number : D31891
 This Issue : 6/5/2006 S.O. No. : NIA Drawing Number : D3189 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : 27190 Material : NIA
 Written By : *SAD* (comment below) Due Date : 6/16/2006 Qty: *12* Each
 Checked & Approved By : *06-06-05*
 Comment : Est. B 05-06-22 No longer made in-house KJ/JLM
 Est Rev:C 06-03-24 Rolling Now made in House JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.3360 sf(s)/Unit Total : 3.3600 sf(s)
 304/316 SS .020" Sheet
 (M304S25GA)
 Batch: *M101000*

SAD 06:06:06

12

2.0 SHEAR SHEAR



Comment: SHEAR
 Cut to size as per Dwg D3189

SAD 06:06:06

12

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr & Grind Rads as per Dwg D3189

SAD 06:06:06

(12)

2-Roll as per Dwg D3189

SAD 06:06:14

(12)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JC 06-14 *(12)*

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5A134*

Pg 6/15 *(12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 26/06/16

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 11:01:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CHAFING SHIELD

Job Number: 27414

Part Number: D31891

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

12
Done 06/06/16

Job Completion



Done 06/06/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

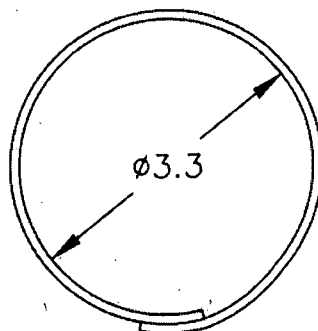
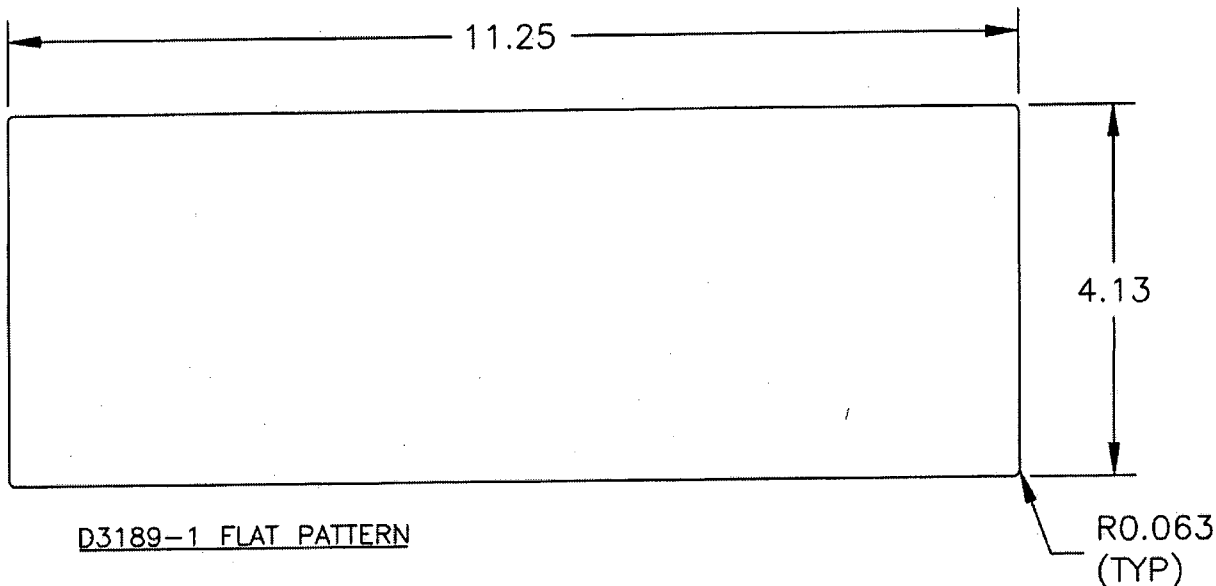
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3189	REV. A SHEET 1 OF 1
DATE 03.05.08		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	

RELEASED
03.05.08 #



D3189-1 ROLLING DETAIL
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27414

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